



Dart Aerospace Ltd.
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RBT18604
Job Sheet 188091



Part No: RBT18604

Job Qty: 1 ea

Part Name: Tail Rotor Swashplate Bearing ReGrease Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/3/19

Job Tracking No:

Due Date: 1/28/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBT18604 Rev.5 IPP Rev. A 18.10.10 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		1/28/19	0.00	0.00	Start Up Small Fab-2		
110	Small Fab	1 pcs		1/28/19	0.00	1.00	Small Fab-3		
120	QC	1 pcs		1/28/19	0.00	0.00	QC5		
130	Packaging	1 pcs		1/28/19	0.00	0.00	Packaging3-1		
140	QC21-FG	1 Ea		1/28/19	0.00	0.00	QC21		

Part Op 110 - 1-Assemble as per DWG.

Descriptions: 130 - The tool must be packaged with a desiccant bag into a tight fitting sealed plastic bag as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
1095K41	Zerk	1 Ea (1 ea)	90-Start up Operation	5075943
2-230	O-Ring	1 Ea (1 ea)	90-Start up Operation	5122105
RBT18604-1	Body	1 Ea (1 ea)	110-Small Fab	5122854
RBT18604-3	Plug	1 Ea (1 ea)	110-Small Fab	5135457

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	1095K41	1	7	0
	2-230	1	102	0
110-Small Fab	RBT18604-1	1	4	0
	RBT18604-3	1	3	0

Part Specifications



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ot be found.

Plex 1/3/19 8:16 AM Dart.lajeunesse.marie

Container No: S144161



Part: RBT18604

Job No: 188091

Serial No/Batch: S144161

Revision: 5

Inspector:

Exp Date:

Instructions:

Date: 01/11/19

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

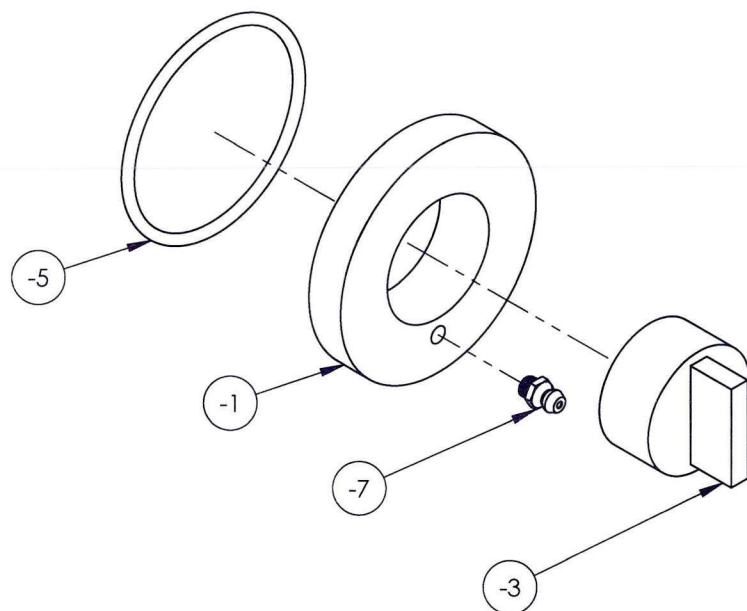
NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		Other/Details:			

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
1		DISTANCE FROM FACE TO STEP INCREASED TO .30 TO ENSURE ADEQUATE THREAD ENGAGEMENT.	3/9/2001	
2		O-RING GROOVE ENLARGED TO BETTER FIT O-RING.	3/23/2001	DW
3		DISTANCE FROM FACE TO STEP REDUCED TO .265.	4/4/2001	
4		GREASE FITTING CH'D TO 45° FOR EASE OF USE, MUST FACE OUT.	2/10/2003	
4A		CH'D TITLEBLOCK & REVISION BLOCK, CH'D REVISIONS FROM ALPHABETICAL TO NUMERICAL, -1 CH'D ENGRAVE NOTE, LABELED SECTION VIEW.	1/13/2010	RJC
5	16-0202	-1 CH'D DIM WAS Ø3.00 CLEANUP IS Ø3.00 ±.02, WAS Ø.09 THRU L-1 Ø.213 ±1/4, 1/4-28 UNF FOR GREASE FITTING IS Ø.09 THRU ALL 1/4-28 -28 ±.25, WAS BORE Ø1.505 ±.012/-000 & THREAD 1.563-18 UNJS -3B PER MIL 8879 IS 1.563-18 UNJS-3B THRU ALL. -3 DELETED DIM .63, ADDED DIM'S 1.38, .65, .13, CH'D MATERIAL WAS NYLON OR DELRIN IS WHITE DELRIN/ACETAL. -5 CH'D B/O INFO WAS PARKER #2-230 IS Ø1/8 X C.S. X Ø2-1/2 I.D. X Ø2.75 (#2-230) CHRISTOPHER SEALS), MAT'L IS BUNA-N. -7 CH'D B/O INFO WAS MSC #08060725 OR EQUIVALENT IS MCMASCTER-CARR #1095K41.	10/24/2016	RJC JAG



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 188091

11-5
1901-03

DART AEROSPACE	
TITLE REGREASE TOOL - SWASH PLATE	
DWG NO. RBT18604	REV 5
MAT'L HEAT TREAT FINISH SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125/✓
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	MD 369 D, E, & F
SCALE 1:2	DATE 10/24/2016 SHEET 1 OF 3

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	BODY	6061		2
			-3	1	PLUG	WHITE DELRIN/ACETAL		3
		B/O	-5	1	O-RING	BUNA-N	Ø1/8 C.S. X Ø2-1/2 I.D. X Ø2.75 (#2-230) (CHRISTOPHER SEALS)	1
		B/O	-7	1	GREASE FITTING	STEEL	STRAIGHT 1/4 -28 SAE-LT MALE (MCMASCTER-CARR #1095K41)	1